



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-636-011
Job Sheet 169856



Part No: D350-636-011

Job Qty: 1 ea

Part Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/2/18

Job Tracking No:

Due Date: 1/26/18

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Heli-Fix Maintenance Inc (CHFIX01)

252 Edouard Drouin St Jerome, QC, J7Y 4X5 Canada ph:(450) 712-3955

Note: DWG REV G SHEETS 1,2,4,8 IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13 As per dsi9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Ver:EC IPP Rev:M 08-04-22 DD verified:EC IPP Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD ver:EC IPP Rev:P 10.06.22 revise seq110 DD ver:EC IPP Rev:Q 10.10.01 as per IIN revH DDver:EC IPP REV:R 13.08.27 PER ECN13-594 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/25/18	0.00	0.00	Start Up Skidtubes-1		
110	Skidtubes	1 pcs		1/25/18	0.00	4.55	Skidtubes-4		
120	QC	1 pcs		1/25/18	0.00	0.00	QC10		
130	QC	1 pcs		1/25/18	0.00	0.00	QC5		
140	HandFinish	1 pcs		1/25/18	0.00	0.93	HandFinish1		
150	QC	1 pcs		1/25/18	0.00	0.00	QC7-2		
160	Skidtubes	1 pcs		1/25/18	0.00	4.55	Skidtubes-4		
170	QC	1 pcs		1/25/18	0.00	0.00	QC10		
180	QC	1 pcs		1/25/18	0.00	0.00	QC5		
190	HandFinish	1 pcs		1/25/18	0.00	0.93	HandFinish2		
205	SprayPaint	1 pcs		1/25/18	0.00	0.53	Spray Paint		
210	QC	1 pcs		1/25/18	0.00	0.00	QC14		
230	HandFinish	1 pcs		1/26/18	0.00	0.93	HandFinish4		
240	QC	1 pcs		1/26/18	0.00	0.00	QC5		
250	Packaging	1 pcs		1/26/18	0.00	0.00	Packaging1-3		
260	QC	1 pcs		1/26/18	0.00	0.00	QC4		
265	DC	1 pcs		1/26/18	0.00	0.00	DC		
270	Packaging	1 pcs		1/26/18	0.00	0.00	Packaging3-1		
280	QC21-FG	1 Ea		1/26/18	0.00	0.00	QC21		

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
Descriptions: D2750 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B) 4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 7-Open up holes of Detail A to 0.297" (total of 2 holes per side) 8-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004
160 - 1-Open up holes using hole saw of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg

DART
AEROSPACE
S032827



Skidtube LH, Std Wearplates, DART (Apical)
Cylindrical/Aerazur Float Comp.

PART NO:

Original Serial #: S032827

Revision:

Operation:

Change No:

Start up Operation
CHG007

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01/16/18
Job No: 169856

D2750. 2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) 3- Open float hole using un-bit to 0.500" (4 per side) 4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8) 5-Debur and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R exp. date: 2018-04-21 ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R 9- At section AJ-AJ drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D2750 11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12-Debur holes, ensure tube is free of all scratches before sending to paint.

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2

210 - Inspect for foreign object per QSI 024

230 - 1- Install inserts as per Dwg D2750 2-Inspect for Foreign Objects 3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: 14138654 EXP DATE: 2018-04-21 4- Assemble o'ring to plug as per dwg D3492 and apply o'ring lube 5- Coat all exposed fasteners with "LPS Procyon" batch: 1133690

260 - *****ensure antiseize is on AN8C21A bolts*****

265 - record fwd angle: 90° Photocopy blue file and type labels per PPP D350-636-011 CHG 007

270 - Package as per PPP D350-636-011 Location : FG072

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2600-3-BENT-LH <u>S030117</u>	1	0	0	0
	D2744 <u>S003318</u>	1	18	0	0
160-Skidtubes <u>B165489</u>	D2739 <u>S026588</u>	1	14	0	0
	D2743 <u>S017322</u>	8	288	0	0
	D3490-1 <u>S017322</u>	4	112	0	0
	D3490-3 <u>S030890</u>	4	17	0	0
230-HandFinish	ALS4-1032-225 <u>S007250</u>	38	1,680	0	0
	AN3C5A <u>S019396</u>	34	1,592	0	0
	AN3C6A <u>S019397</u>	4	277	0	0
	AN6C44A <u>FM137055-1</u>	4	521	0	0
	AN8C35A <u>FM137203</u>	1	96	0	0
	D2745 <u>S00038013</u>	8	238	0	0
	D3488-041 <u>F163522</u>	1	9	0	0
	D3492-1 <u>S025647</u>	8	248	0	0
	D3492-3 <u>S026057</u>	8	239	0	0
	D3535-25 <u>S032628</u>	1	10	0	0
	D3536-25 <u>S031897</u>	1	13	0	0
	D3537-1 <u>S037413</u>	3	95	0	0
	D3631-1 <u>S008168</u>	8	212	0	0
	D3791-1 <u>S031903</u>	1	28	0	0
	D3793-1 <u>S032647</u>	1	8	0	0
	D3793-3 <u>S032647</u>	1	9	0	0
	D3794-1 <u>S031919</u>	1	4	0	0
	D3794-3 <u>S032222</u>	1	7	0	0
	MS21043-6 <u>S016883</u>	4	94	0	0
	MS21083C8 <u>S034401</u>	1	91	0	0
	NAS1149C0332R <u>S019380-1</u>	38	5,228	0	0
	NAS1149C0832R <u>FM135536-0</u>	113	0	0	0
	NAS1515H3L <u>FM137361-25</u>	4	170	0	0
	NAS1611-010 <u>FM138441-2</u>	8	434	0	0
	NAS1611-013 <u>S022099</u>	8	305	0	0
250-Packaging	AN8C21A	2	223	0	0
	D2741	1	40	0	0
	D3493-1	2	32	0	0
	D3532-1	2	5	0	0
	MS21083C8	2	91	0	0
	NAS1149D0863J	2	199	0	0

Part Specifications

Specifications could not be found.

000469

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN8C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN980C10L	WASHER
1	1	1	1	AN980C818L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

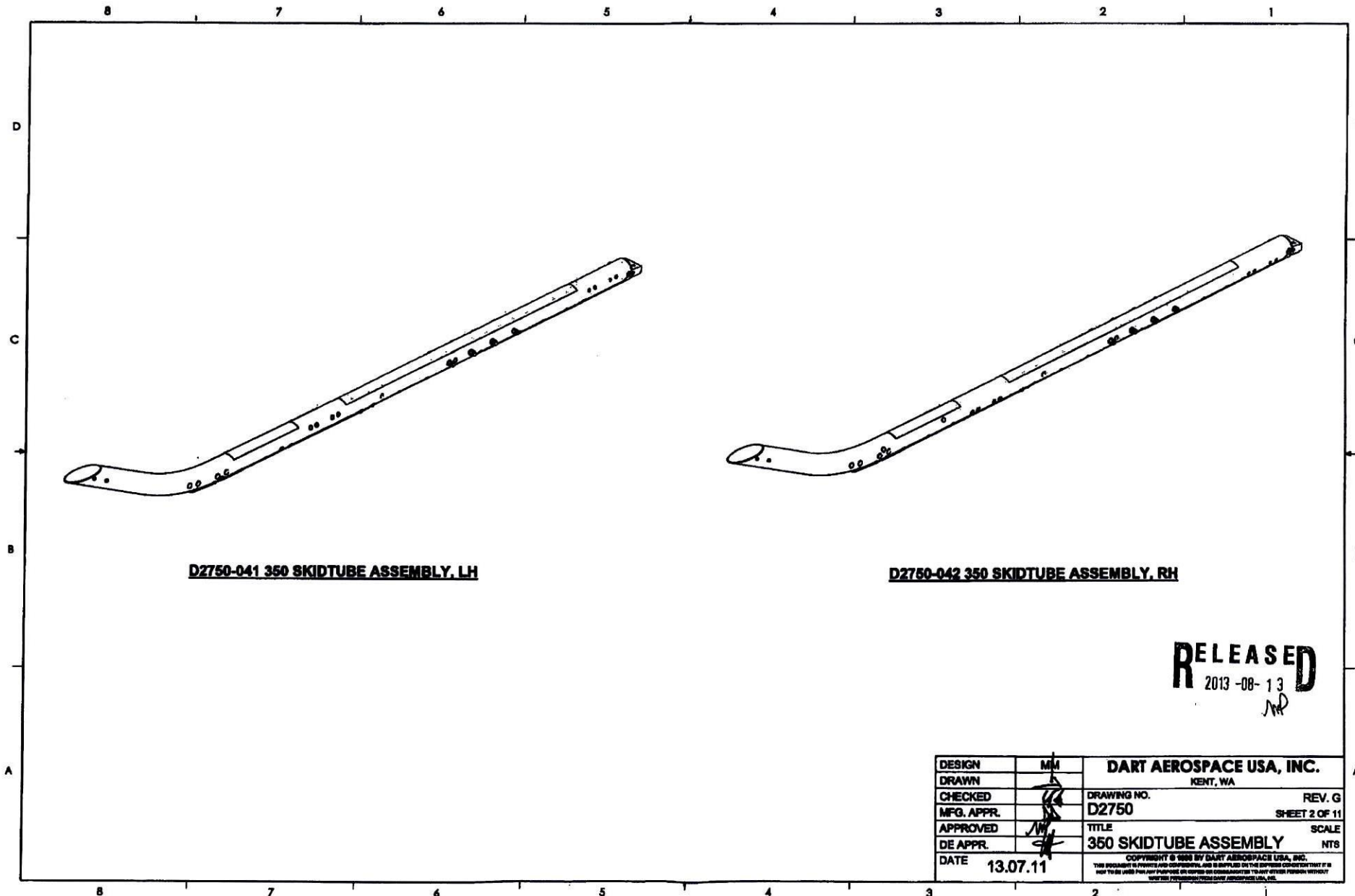
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G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.010/-0.000$, WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3; REASON: PART13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN980C818; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24894-S283 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
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KENT, WA

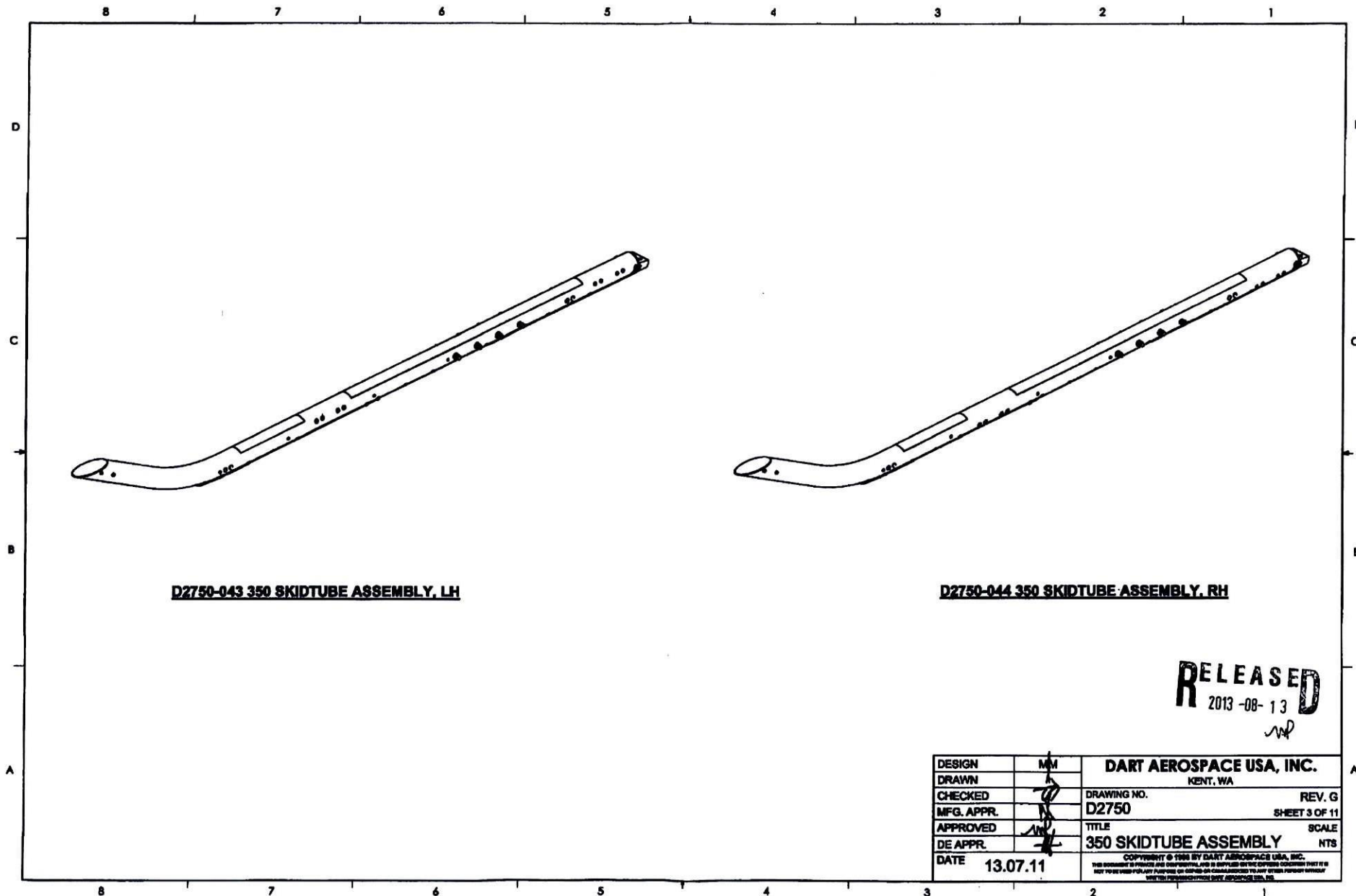
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SHEET 1 OF 11
TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS

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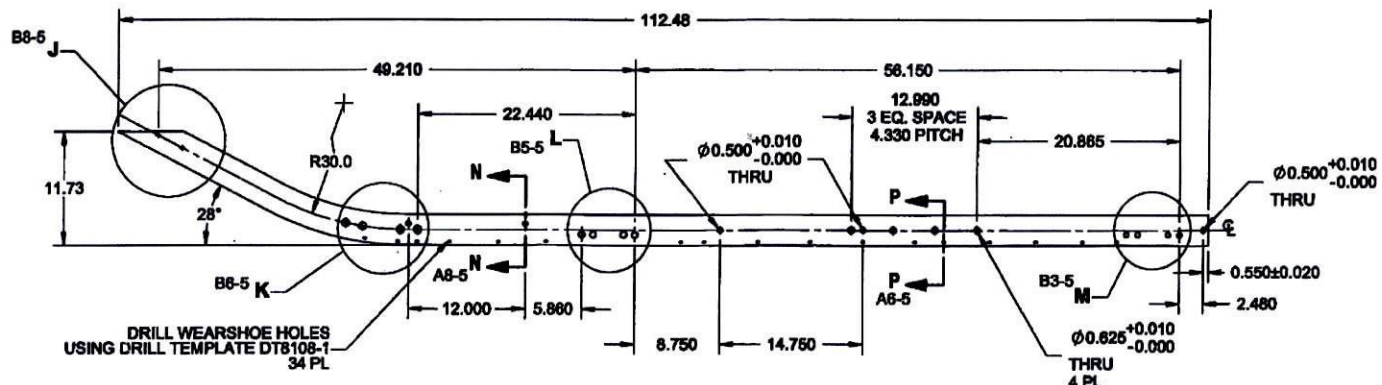
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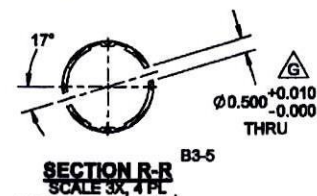
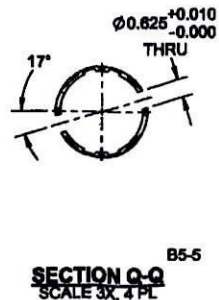
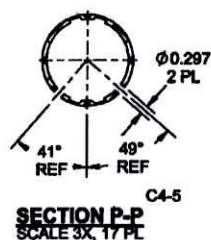
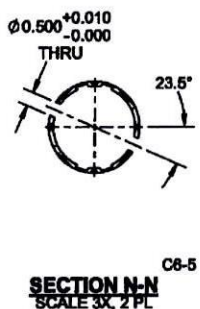
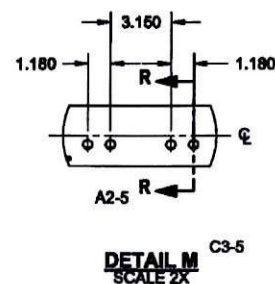
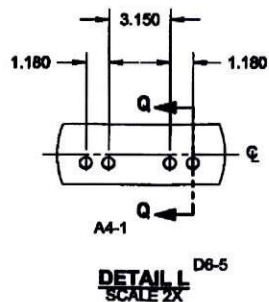
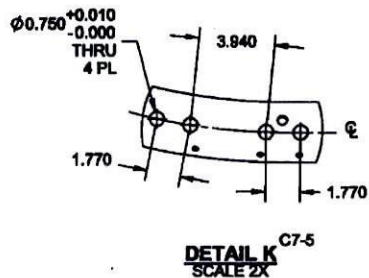
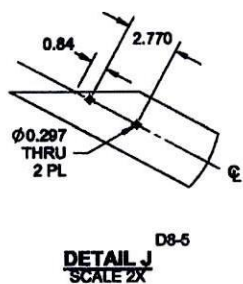


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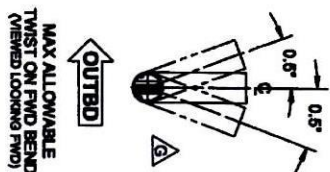


D2750-2 RH SKIDTUBE



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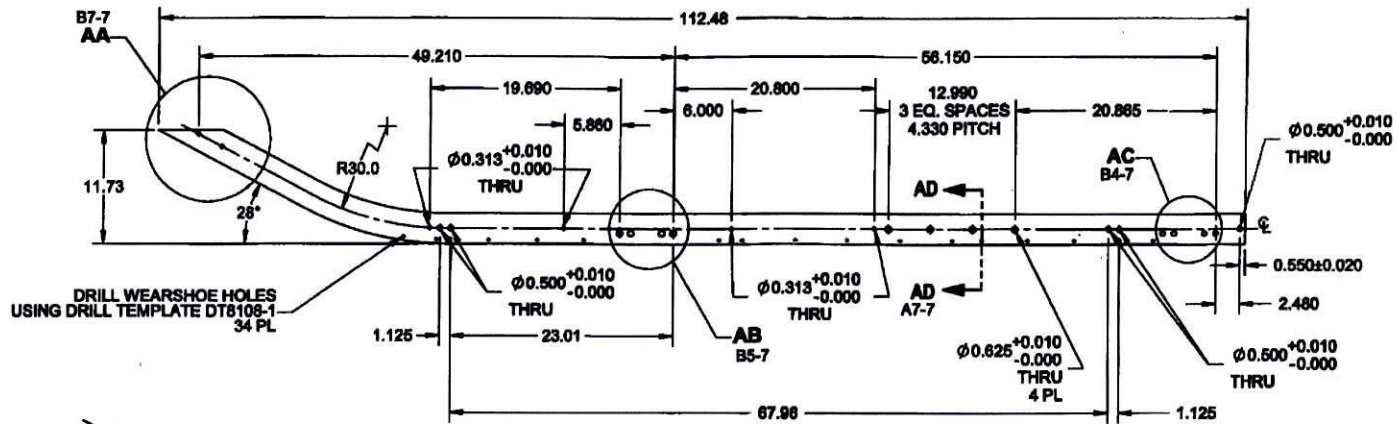


**MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)**

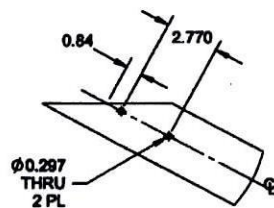


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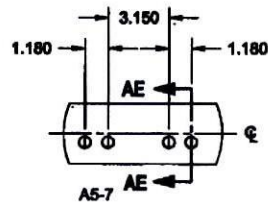
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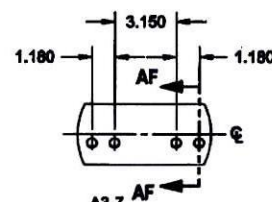
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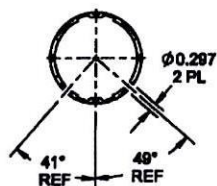
DETAIL AA
D7-7
SCALE 2X



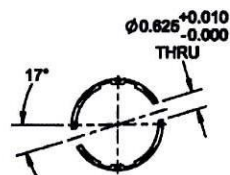
DETAIL AB
C4-7
SCALE 2X



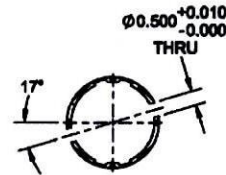
DETAIL AC
D3-7
SCALE 2X



SECTION AD-AE
D3-7
SCALE 3X, 17 PL



SECTION AE-AE
B6-7
SCALE 3X, 4 PL

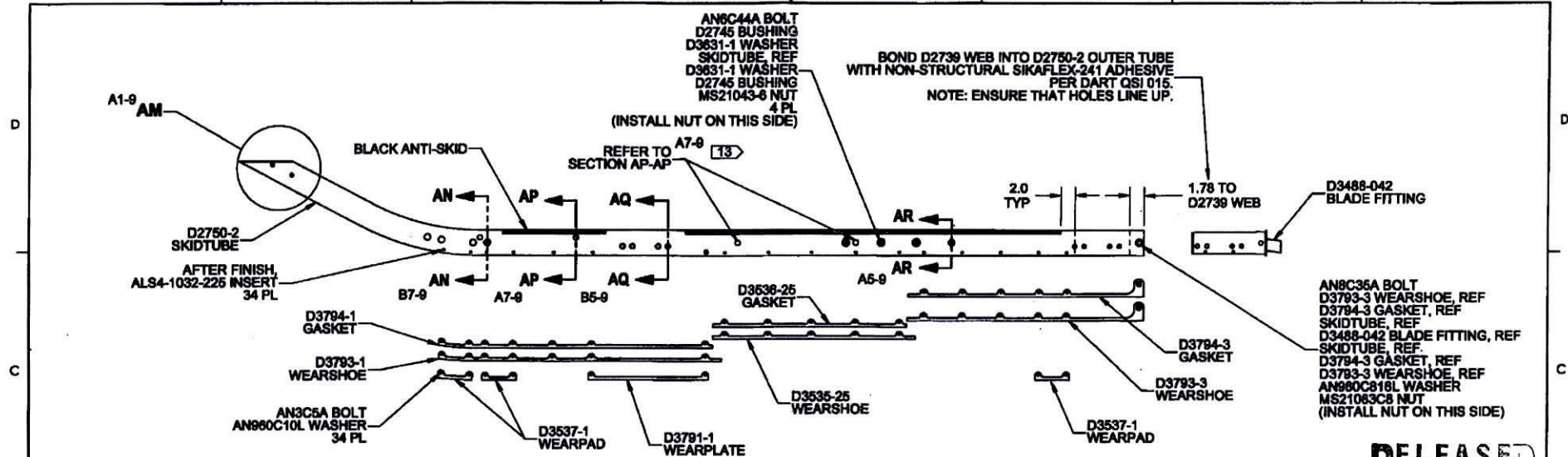


SECTION AF-AF
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SCALE 3X, 4 PL

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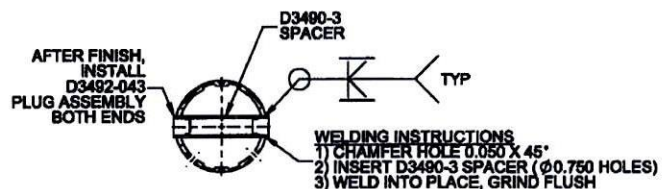
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APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1986 BY DART AEROSPACE USA, INC. MANUFACTURED BY DART AEROSPACE USA, INC. IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

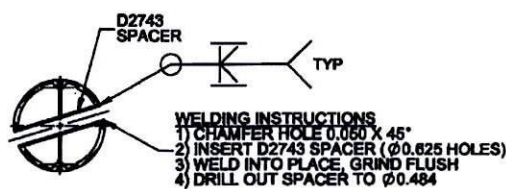


D2750-042 350 SKIDTUBE ASSEMBLY, RH

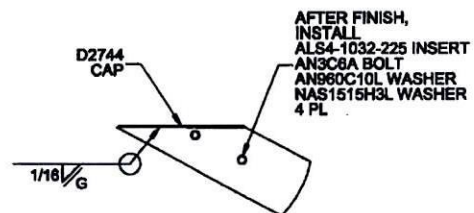
RELEASED
2013-08-13



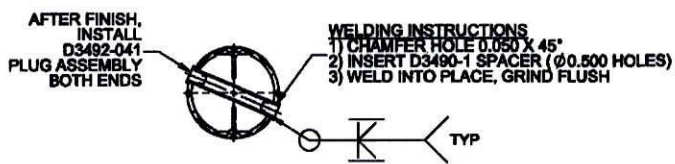
SECTION AN-AN
SCALE 3X, 4 PL



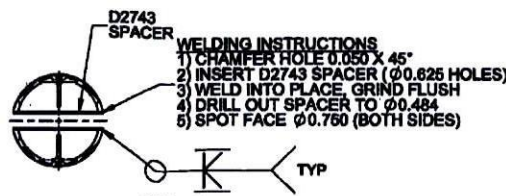
SECTION AQ-AQ
SCALE 3X, 4 PL



DETAIL AM
SCALE 2X



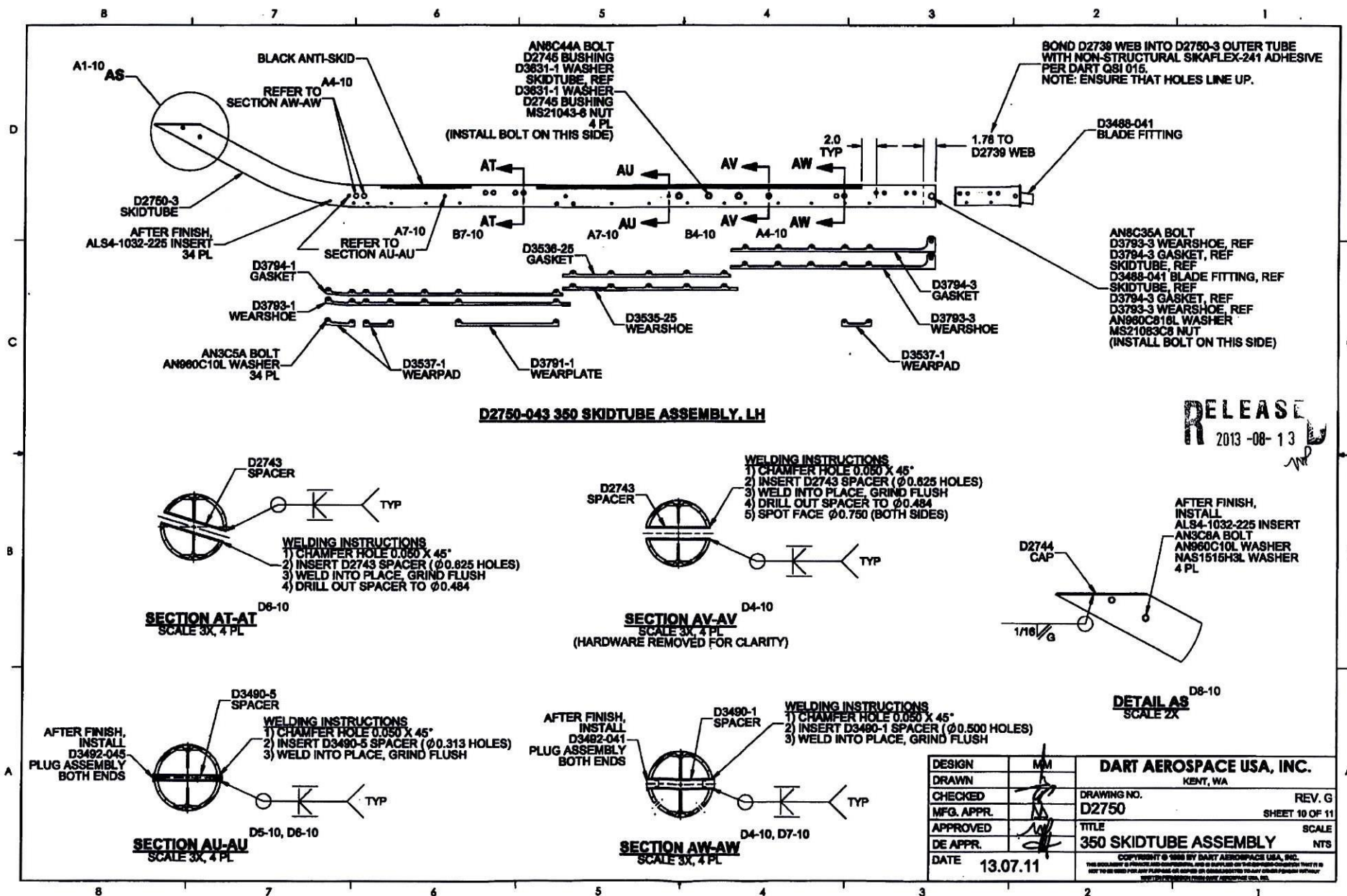
SECTION AP-AP
SCALE 3X, 4 PL



SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 9 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Master Unit 000469

Tel (613) 632-5200

Containers on Master Unit 000469				
Serial No	Part No	Customer Part No	Status	Quantity
S038725	AN8C21A	AN8C21A	Allocated	2
S038724	D2741	D2741	Allocated	1
S038723	D3493-1		Allocated	2
S038722	D3532-1		Allocated	2
S038721	MS21083C8	MS21083C8	Allocated	2
S038720	NAS1149D0863J	NAS1149D0863J	Allocated	2